

Monday, November 30, 2015 11:07:53 AM

139558

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Supporting Plate

Stop *NS2*

Start Date: 11/30/2015 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 11/30/2015 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: MCS Date: DEC 02 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Stop *NS2*

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Cust Item ID:

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
5	15	212	9 9-89

120

QC8- Inspect parts - second check

0.00

120

OC

Memo

0.00

Quality Control

130

130

Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

1-counter sink holes as per dwg D3781
2- deburr if necessary

5x _____ 15/12/21

140

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⑤ 15-12-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Monday, November 30, 2015 11:07:53 AM

139558

Page 3

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/30/2015 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 11/30/2015 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

Small Fab

Memo

0.00

Small Fab

1- assemble nut plate as per dwg

DAS
36
9-89

DAS
36
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 139558***139558***

Page 4

Monday, November 30, 2015 11:07:53 AM

Item ID: D3781-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Supporting Plate

Start Date: 11/30/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/30/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00				(5)			DAS 38 9-89
Quality Control									JAN 04 2016
190	Identify as per dwg & Stock Location: <u>Stasy</u>	0.00							
190									
Packaging	Memo	0.00				S			DAS 6 9-89
Packaging									JAN 04 2016
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00				MLJ			JAN 05 2016
Quality Control									

MLJ JAN 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 16.6%;">Skid-tube ☐</td> <td style="width: 16.6%;">Cross tube ☐</td> <td style="width: 16.6%;">Water Jet ☐</td> <td style="width: 16.6%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Monday, November 30, 2015 11:07:52 AM

Page 1

Work Order ID: 139558

139558

Parent Item: D3781-1

D3781-1

Parent Item Name: Supporting Plate

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP RevA: revD as per dwg DD verified by:EC
as per dwg RevE DD 10.04.27 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	248.6000	0.1062	0.558948			

M6061T6S 080

6061-T6 .080 Sheet

15/12/18

Location	Loc Qty	Loc Code
MAT020	248.6	
m132099	32	
m132772	120.6	
m133587	96	

MS20426AD3-3

Purchased

No

170

Each

4,644.000

4

20

MS20426AD3-3

RIVET

15/12/26
DAS
36
9-89

Location	Loc Qty	Loc Code
GA	1862	
M131624	1862	
ST312	2782	
M131624	2782	

MS21075L3

MS21075L3N

Purchased

No

170

Each

78.0000

2

10

MS21075L3

Nut Plate

15/12/21
DAS
36
9-89

10x
1128429

Location	Loc Qty	Loc Code
ST298	78	
M131153	78	

DQA: _____ Date: _____

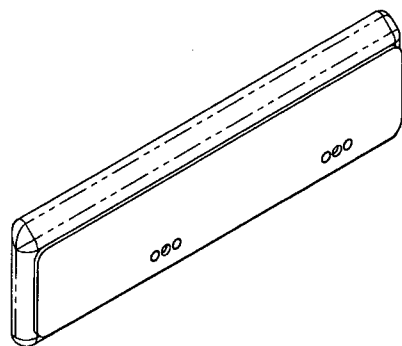


WORK ORDER NON-CONFORMANCE / UPDATE

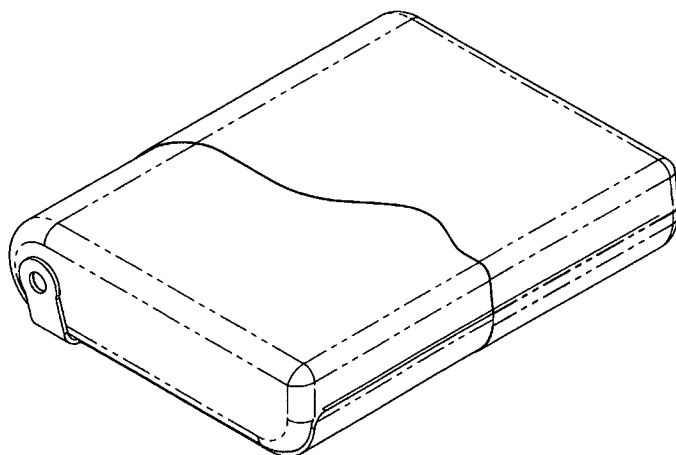
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



D3781-041 LATERAL CUSHION ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 ARMREST CUSHION
(UPHOLSTERY FABRIC NOT SHOWN PARTIALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

139558-ML5

1512-02

RELEASED
2010-04-26

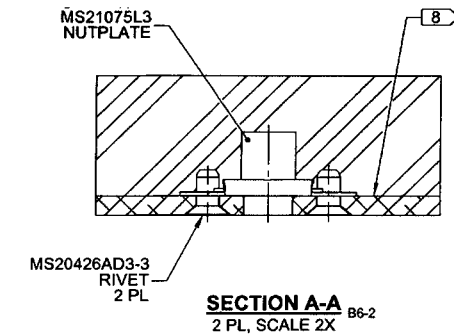
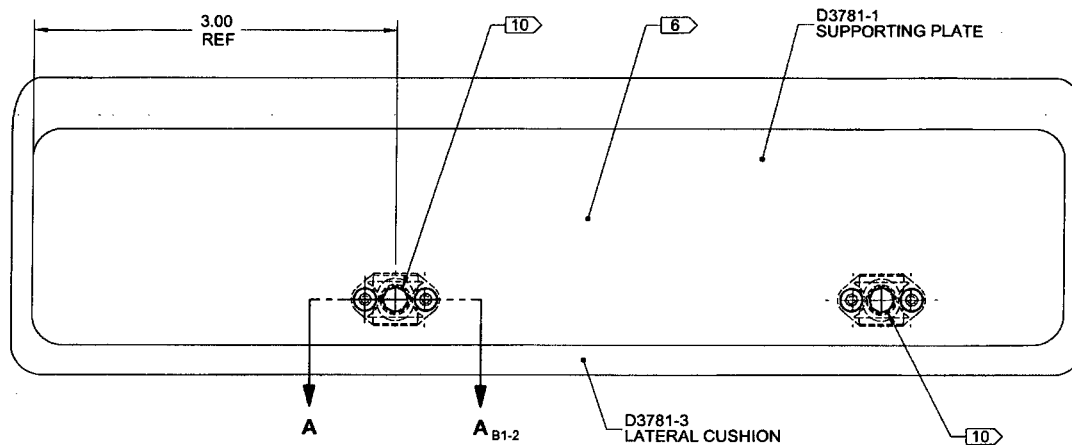
E	REMOVED ZIPPER FROM D3781-043. SHEET 3 REVISED ACCORDINGLY. REASON: MANUFACTURABILITY PER NCR 10-012.	MB	10.04.14
D	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.21
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3781** REV. E
SHEET 1 OF 6
TITLE **CUSHION ASSEMBLY** SCALE NTS

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ITEM	QTY	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



D3781-041 LATERAL CUSHION ASSEMBLY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

D3781-041 NOTES:

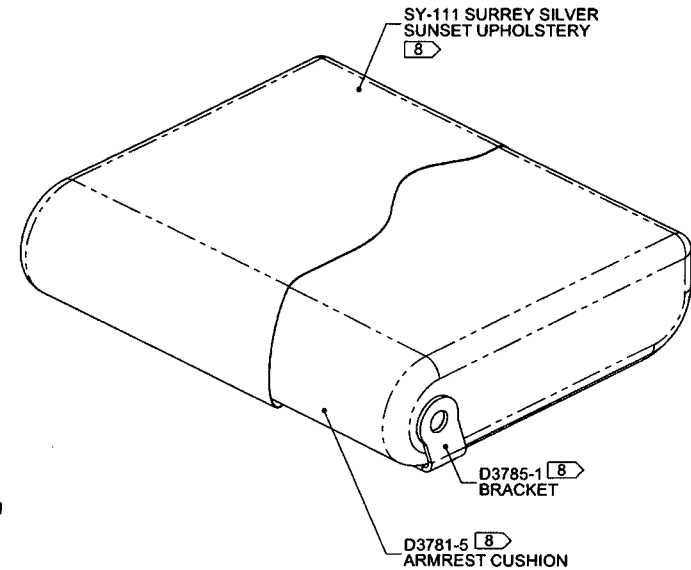
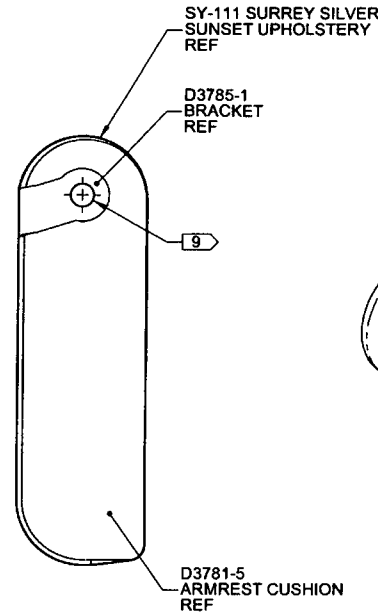
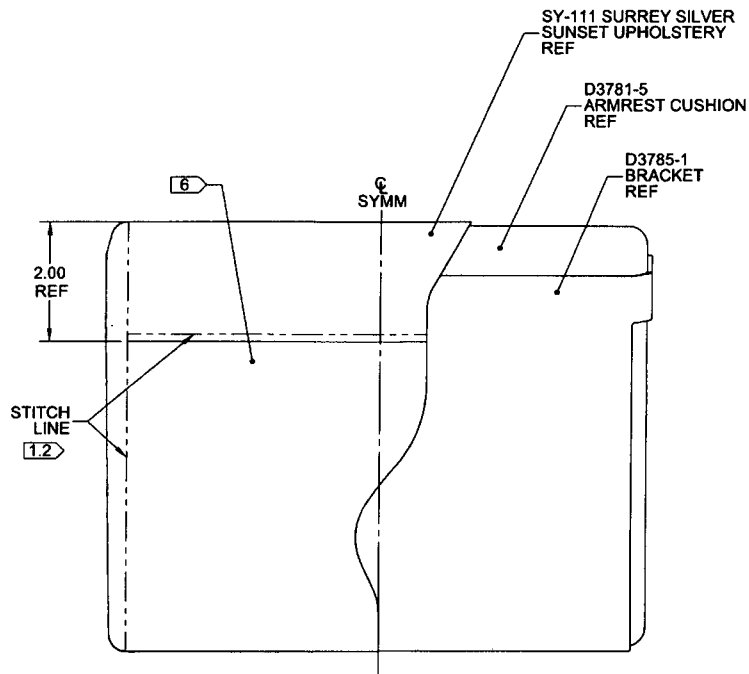
- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111. BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS. POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

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CHECKED		DRAWING NO. D3781
MFG. APPR.		REV. E
APPROVED		SHEET 2 OF 6
DE APPR.		TITLE CUSHION ASSEMBLY
DATE	10.04.14	SCALE NTS

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ITEM	QTY	P/N	DESCRIPTION
1	X	D3781-043	ARMREST CUSHION ASSEMBLY
3	1	D3781-5	ARMREST CUSHION
4	1	D3785-1	BRACKET
6	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY
7	A/R	1300	3M SCOTCH-GRIP ADHESIVE



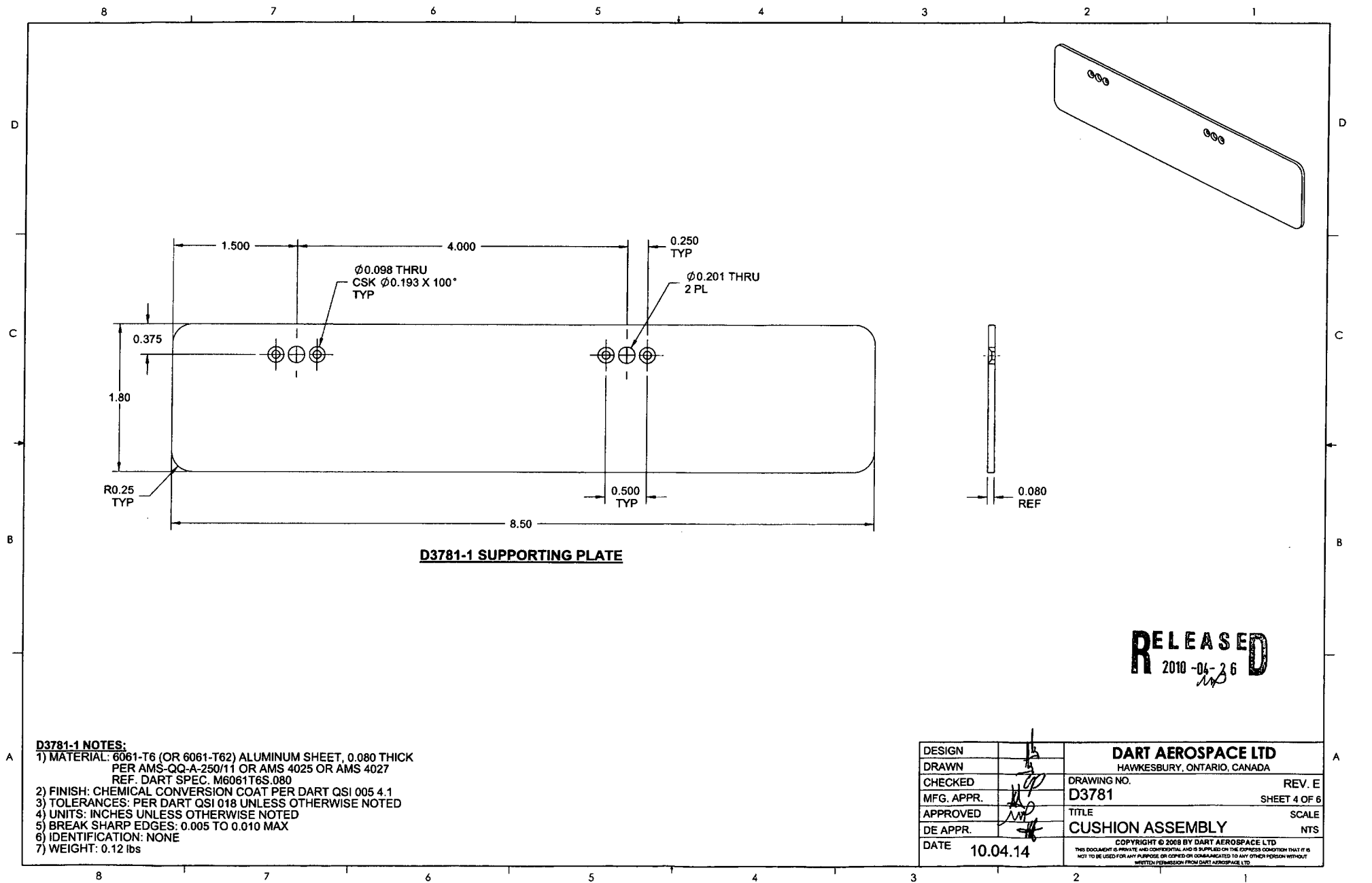
D3781-043 LATERAL ARMREST CUSHION BASE ASSY
(UPHOLSTERY FABRIC SHOWN PARTIALLY FOR CLARITY)

D3781-043 NOTES:

- 1) MATERIAL:
 - 1.1) SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
 - 1.2) THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
 - 1.3) ADHESIVE: 3M 1300/1300L
 - 1.4) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) COVER D3781-5/D3785-1 ASSEMBLY WITH FABRIC (ITEM 6). BOND FABRIC TO PLATE USING ITEM 7 (0.002" TO 0.010" THICK)
- 9) DO NOT COVER HOLES WITH FABRIC

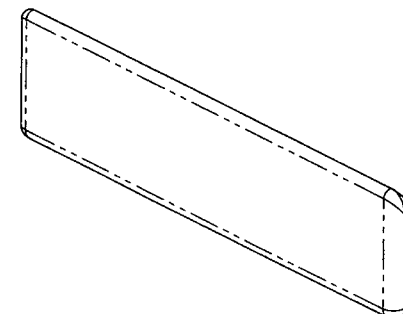
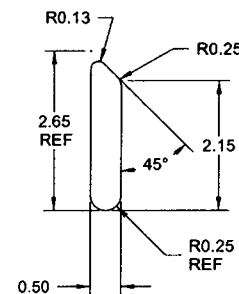
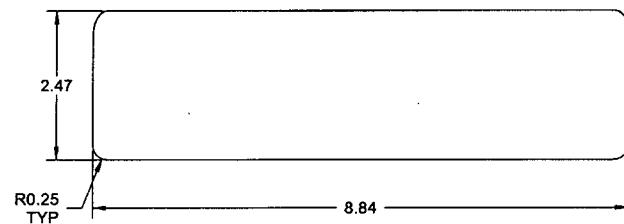
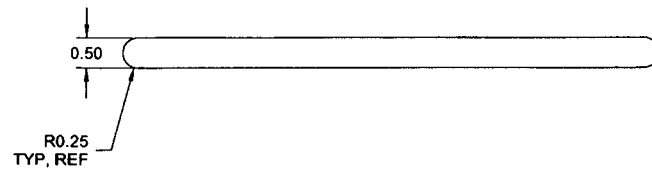
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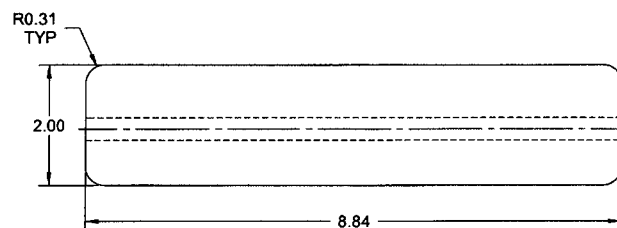
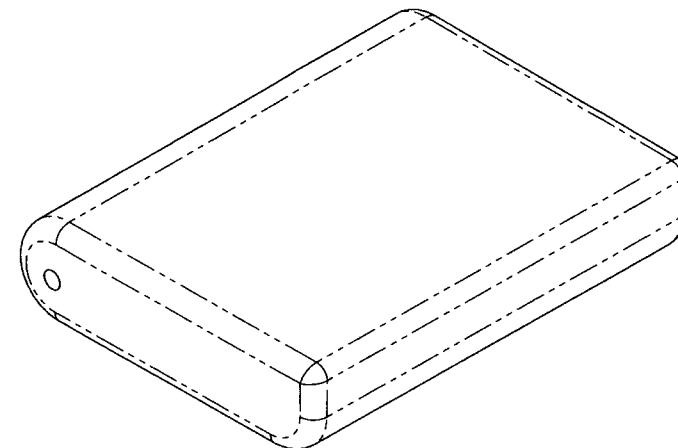
D3781-3 LATERAL CUSHION

D3781-3 NOTES:

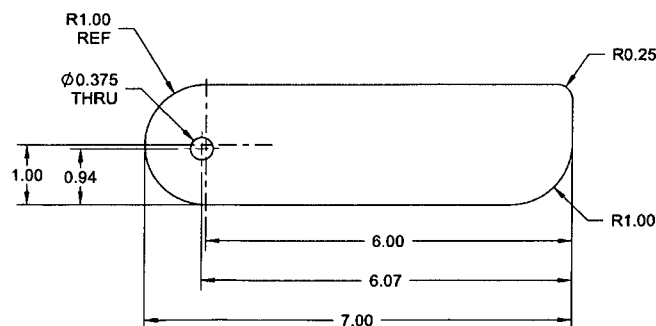
- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

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MFG. APPR.		D3781	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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D3781-5 ARMREST CUSHION



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D3781-5 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

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DE APPR.			NTS
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